

161857

Tuesday, May 23, 2017 10:58:28 AM

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Reference:

MAY 23 2017

Date:

Run Start *NR1*

Date:

Stop *NR2*

**Insp.
Stamp**

E

0.48

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D4008-3)

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.04

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 161857***161857***

Page 2

Tuesday, May 23, 2017 10:58:28 AM

Item ID: D4008-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Pump Splash Guard Assembly
Start Date: 5/30/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/8/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				4			DAS 38 9-89 MAY 31 2017
130 *130* Brake NC Brake NC	Bend as per dwg Memo 1- Bend D4008-3 as per dwg 2- Dimple holes as per dwg	0.36 0.40			DAS 30 9-89	4x			DAS 36 9-89 17/06/07
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				4			DAS 38 9-89 JUN 07 2017

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Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							DAS 41 9-89
160						4			
SprayPaint	Memo	0.12							
Spray Painting	1- PRIME TEMPO GREY (4.2.1.3.2) AS PER DWG PRIMER BATCH: 137487								JUN 08 2017
	2- PAINT FLAT GREY (4.2.2.3) AS PER DWG PAINT BATCH: 136996								
170	QC14- Inspect Spray Paint	0.00							DAS 16 9-89
170						(x4)			17/06/12
QC	Memo	0.04							
Quality Control									
180		0.06							DAS 36 9-89
180						4X			17/06/12
Small Fab	Memo	0.37							
Small Fab	Assemble as per dwg								

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
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Work Order ID 161857

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161857

Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				4			DAS 38 9-89 JUN 13 2017
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: S243 Memo	0.00 0.04				4			JUN 13 2017 DAS 6 9-89
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40							17/6/14 JUN 13 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, May 23, 2017 10:58:26 AM

Page 1

Work Order ID: 161857

161857

Parent Item: D4008-043

D4008-043

Parent Item Name: Fuel Pump Splash Guard Assembly

Start Date: 5/30/2017

Required Date: 6/8/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07
AS PER DWG REV.C DD VERF:EC IPP REV:D 15.01.15 AS PRE
DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4597-1 *D4597-1* Placard		Manufactured	No			180	Each	5.0000	1	4			DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST111		5							
					154451	5		12/23/2017		4			
M304S24GA *M304S24GA* 304/316 .025 Sheet		Purchased	No			100	sf	38.4700	0.441	1.856842			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		38.47							
				m135780		6.47							
				m136896		32				2			
MS20427M3-3 *MS20427M3-3* Rivet		Purchased	No			180	Each	1,712.000	8	32			DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		471							
				m134738		471				32			
				ST311		1241							
				m136741		1241							

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Tuesday, May 23, 2017 10:58:26 AM

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Work Order ID: 161857

161857

Parent Item: D4008-043

D4008-043

Parent Item Name: Fuel Pump Splash Guard Assembly

Start Date: 5/30/2017

Required Date: 6/8/2017

Start Qty: 4.00

Required Qty: 4.00

MS21059L3

Purchased

No

180

Each

134.0000

4

16

MS21059L3

Nut Plate

**

DAS
36
9-89

DAS
22
17.06.12

Location

Loc Qty

Loc Code

GA

75

M137412

75

ST301

59

M137164

9

M137587

50

17/06/12

127635

16x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

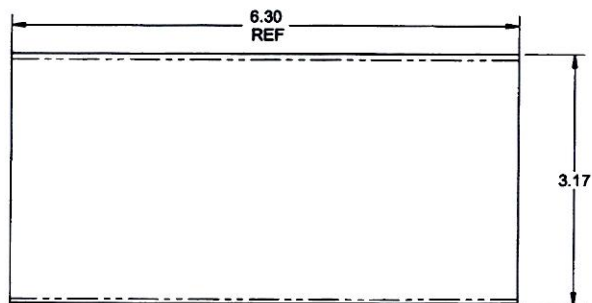
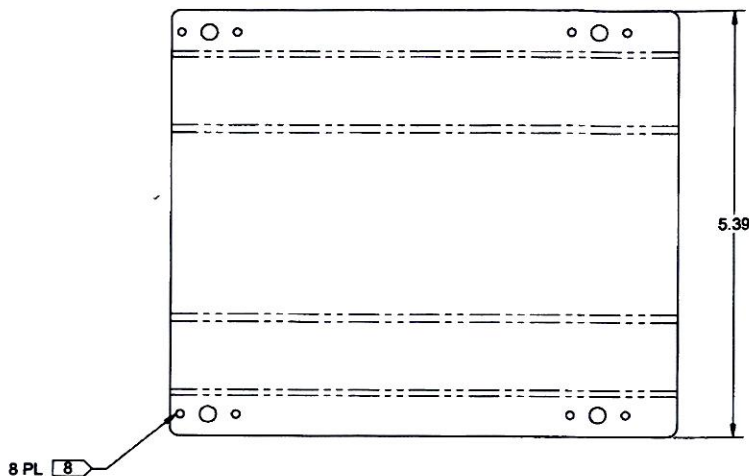
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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE
PART NUMBER

D4008-3

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-29

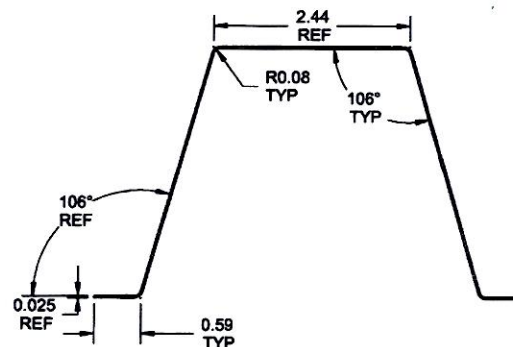
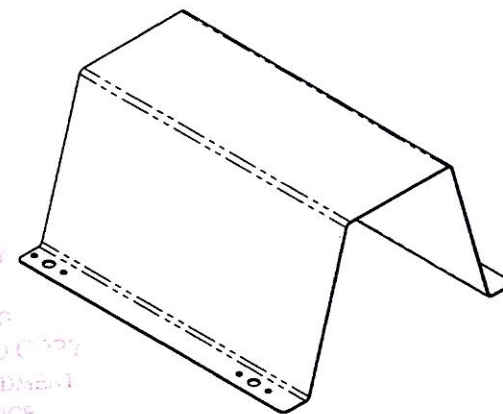


D4008-3 FUEL PUMP SPLASH GUARD COVER
(MAKE FROM D4008-3F)

NOTES:

- 1) MATERIAL: MADE FROM D4008-3F
- 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs
- 8) DIMPLE ON OPPOSITE SIDE SHOWN FOR COUNTERSUNK RIVETS TO $\phi 0.179 \times 100^\circ$

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16187
MAY 23 2017



RELEASED
2015 JAN 15

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. E
MFG. APPR.	JLM	D4008	SHEET 5 OF 10
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPLASH GUARD	NTS
DATE	14.12.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

